

Date: Friday, 26/09/2008 10:58:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 42298		
Estimate Number	: 12961		
P.O. Number	:	Part Number	: D36411
This Issue	: 26/09/2008 S.O. No. :	Drawing Number	: D3641 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 34542	Material	:
Written By	:	Due Date	: 06/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUD 08.9.26</u>		
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6032 M5052-11325.032	6061-T6 Sheet 0.032"
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Comment: Qty.: 0.8244 sf(s)/Unit Total: 9.8923 sf(s)

~~M6061-T6 .032" THK sheet~~

Batch: M5052-432 108724 LB 8-10-20

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: B

Prog Rev: B

LB 8-10-20

2-Deburr if necessary

LB 8-10-20

(13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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LB 8-10-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/21 (13)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3641-1

SB 08/10/22

(13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 42298

Part Number: D36411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/27 (13)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/10/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/10/28 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: PC 8/14/28 (13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 08/10/28 (13)

Job Completion



4 08.10.28

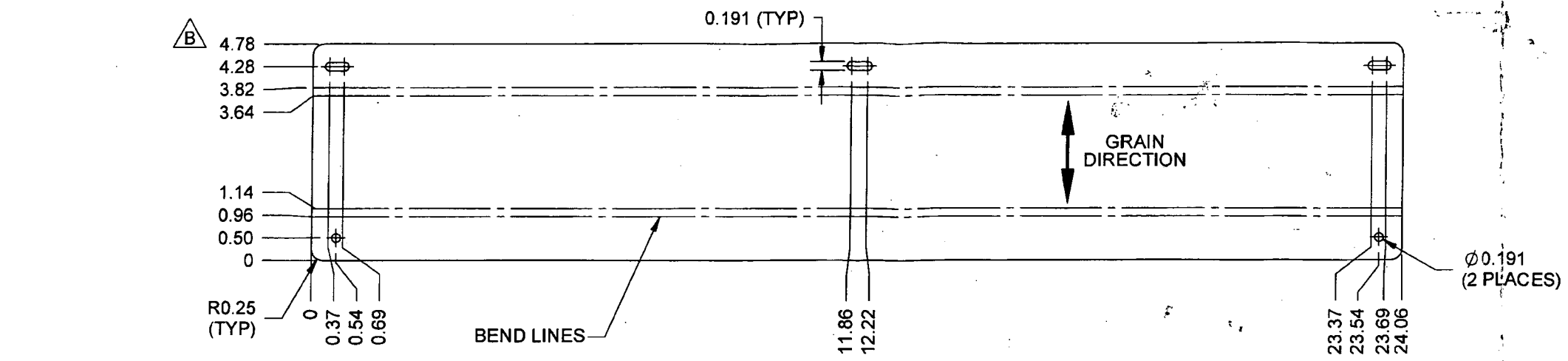
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

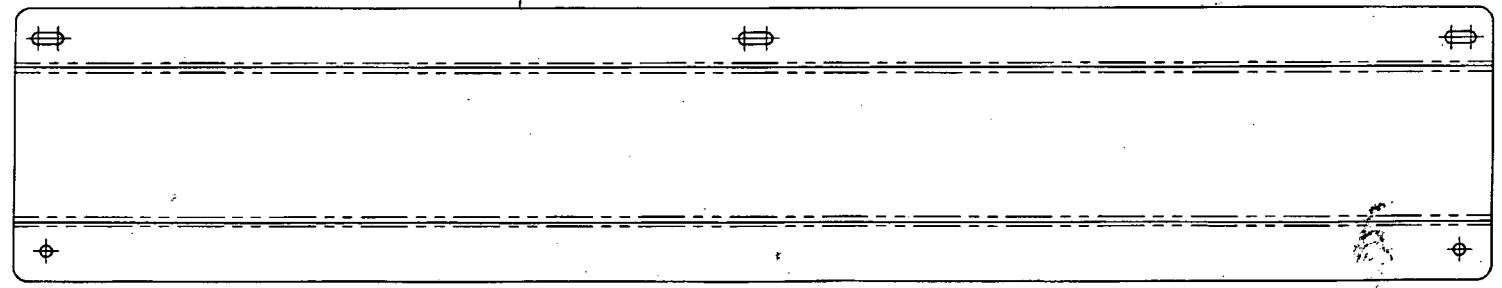
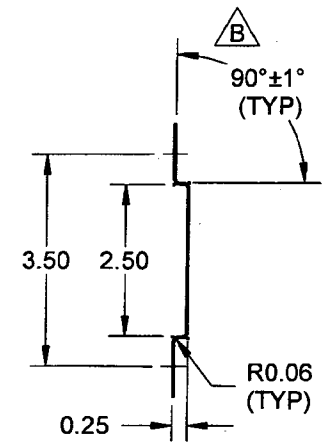
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



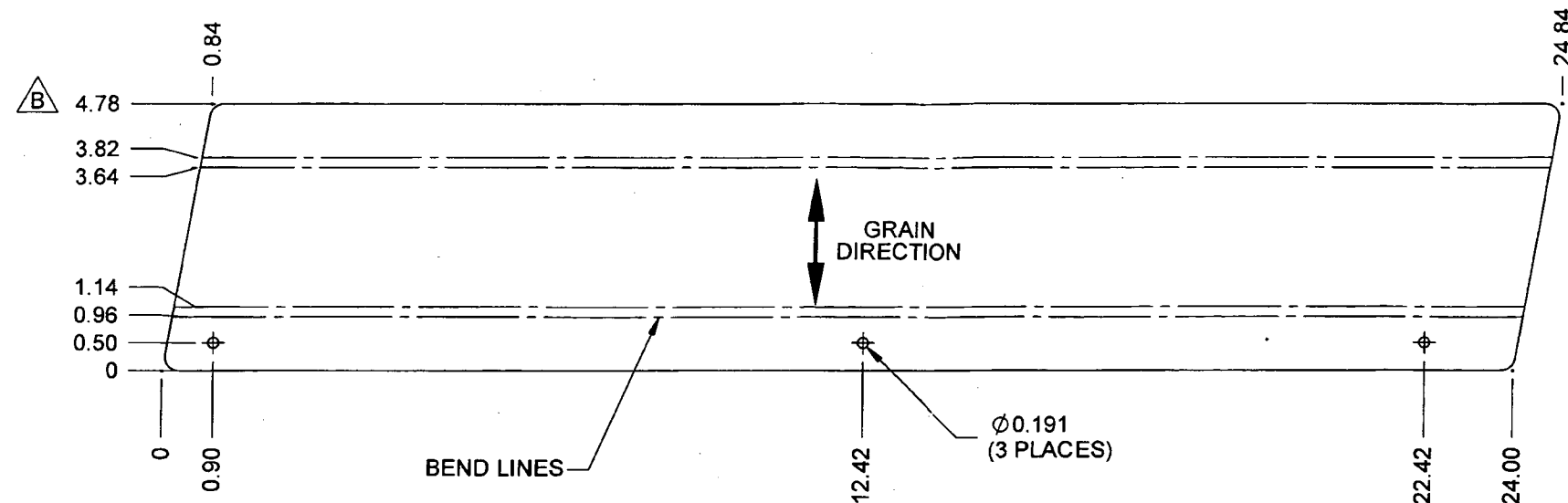
**D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)**

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.35 lbs

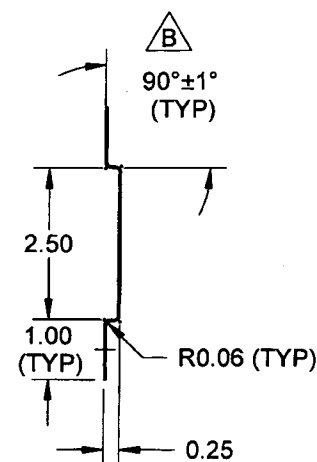
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	MA	DRAWING NO.	REV. B
MFG. APPR.	MA	D3641	SHEET 1 OF 2
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	COVER	1:3
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D3641-3F FLAT PATTERN



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
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CHECKED	PAH	DRAWING NO.	REV. B
MFG. APPR.	PAH	D3641	SHEET 2 OF 2
APPROVED	PAH	TITLE	SCALE
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